

Work Order ID 61178

August 11, 2010 7:42:30 AM



Page 1

Item ID:	D3826-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib / Gusset Assembly					
Start Date:	8/11/10	Start Qty:	6.00		Cust Item ID:	
Required Date:	8/17/10	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>10/8/11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3826	Rev B								

100



Large Fab

Large Fab

Large Fab

Memo

1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod
Batch: M113328

0.00

0.00

10/08/27 CL

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

10.08.31

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

10/08/31

(x6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3826-041

Accept

Revision ID:

Item Name: Rib / Gusset Assembly

Start Date: 8/11/10 Start Qty: 6.00

Required Date: 8/17/10 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Basket cell

Memo

0.00

Packaging

10/08/31 (6x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/31
MF
10-8-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61178

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly

Start Date: 8/11/10

Required Date: 8/17/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓ D2235-1 Basket Rib		Manufactured	No				Each	14.0000	1	6		10/08/26	
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Location	Loc Qty	Loc Code
WA	14	
60274	4	
60832	10	

✓ D3929-041 Gusset Assembly		Manufactured	No				Each	5.0000	1	6		10/08/26	
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Location	Loc Qty	Loc Code
WA	5	
60327	5	

✓ D3929-042 Gusset Assembly		Manufactured	No				Each	6.0000	1	6		10/08/26	
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Location	Loc Qty	Loc Code
WA	6	
60446	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. Cell 178
C2101811

D3826-041 RIB/GUSSET ASSY

RELEASED
5/10/12

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.		BY	DATE
DESIGN	<u>16</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>16</u>		
CHECKED	<u>16</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>16</u>	D3826	SHEET 1 OF 2
APPROVED	<u>16</u>	TITLE	SCALE
DE APPR.	<u>16</u>	RIB/GUSSET ASSY	NTS
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△ D3829-042
GUSSET ASSEMBLY

△ D3829-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

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WITHOUT NOTICE
WORK ORDER
NO. 61178
C210/811

RELEASED
9/24/12

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CHECKED		DRAWING NO.	REV. B
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